

to place the block in the jig and feed the drill to the work. Brushes are unnecessary; as the chips clear themselves and the blocks are freed from chips as they slide over the perforated section of chute *E*.

For drilling the three holes in the sides, a multiple drill head is used and the piece is held in a jig which is a duplicate of the one shown, except that the templet which guides the drills is

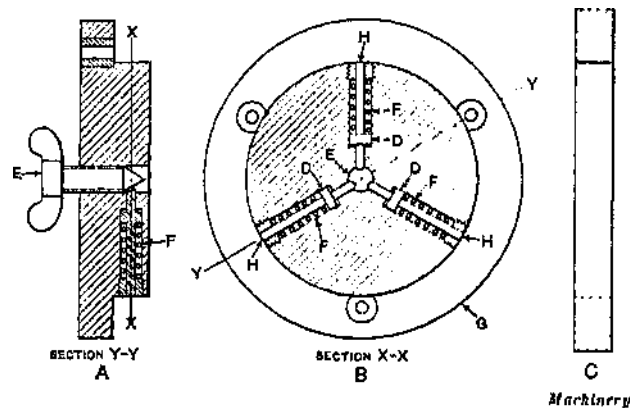


Fig. 4. Jig for Holding Ring while drilling

attached to the stationary jaw and is provided with three holes for guiding the three drills.

Jig for Drilling Ring. — The jig shown in Fig. 4 at *A* and *B* is used for drilling the ring shown at *C*. Referring to the illustration at 5, it will be seen that there are three plungers *D* held against the conical point of wing-screw *E* by springs *F*. In operation, the wing-screw *E* is turned back until the plungers *D* are just

within the body *G* at points //, The ring *C* is then slipped on and the wing-screw turned clown until the plungers *D* are forced out and into contact with the inside surface of the ring. The ring is then drilled on a sensitive drilling machine.

Indexing Jig operated by Hand-lever and Foot-treadle.— The drill jig shown in Fig. 5 was designed for drilling four angular holes in a brass time-fuse cap. (See sectional view of cap at lower part of illustration.) The principle of this jig can